

Work Order ID 149009

149009

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July 14, 2016 2:13:39 PM

Item ID: D139-799-033 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: OEM Maintenance Step Cable Replacement

Start Date: 7/14/2016 Start Qty: 3.00 *3*

Required Date: 7/19/2016 Req'd Qty: 3.00 *3*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SW Date: 7/14/16 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D139-799	K								
100		0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D139-799-033 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.02							
Quality Control									

X3 DAS 27 9-89

AUG 16 2016

3 DAS 27 9-89

PK JUL 18 2016

X3 DAS 27 9-89

AUG 16 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

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Item ID: D139-799-033

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: OEM Maintenance Step Cable Replacement

Start Date: 7/14/2016 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D139-799-033

Location: _____

PPP rev: _____

fg 122

Y3
DAS
27
9-89
AUG 16 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.05

Quality Control

DAS
21
9-89
AUG 16 2016DAS
21
9-89
AUG 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
20					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 149009

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Parent Item: D139-799-033

D139-799-033

Parent Item Name: OEM Maintenance Step Cable Replacement

Start Date: 7/14/2016

Required Date: 7/19/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.05.26 chg001/ECN14-567 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-832R10		Purchased	No				Each	110.0000	4	12			PC
AN525-832R10													
SCREW													

Location Loc Qty Loc Code

ST326 100

m134754 100

ST328 10

m128936 10

DAS
27
9-89

AN525-832R14

Purchased No

Each 76.0000

AN525-832R14

Screw

Location Loc Qty Loc Code

ST328 76

m134512 76

DAS
27
9-89

AN525-832R9

Purchased No

Each 88.0000

AN525-832R9

Screw

Location Loc Qty Loc Code

ST328 88

m134513 88

DAS
27
9-89

D5039-5

Manufactured No

Each 32.0000

D5039-5

Half Link

Location Loc Qty Loc Code

ST144 32

142339 32

DAS
27
9-89

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Work Order ID: 149009

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Parent Item: D139-799-033

D139-799-033

Parent Item Name: OEM Maintenance Step Cable Replacement

Start Date: 7/14/2016

Required Date: 7/19/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L08

Purchased

No

Each

1,022.000

8, 24

**

PC

MS21042L08

Nut

Location

Loc Qty

Loc Code

GA

172

m133134

3

m134063

169

ST303

833

m133922

37

m134574

4

m134654

142

m134962

200

m135046

350

m135133

100

ST308

17

m134376

17

Each

3,518.000

6 18

**

PC

NAS1149C0332R

Purchased

No

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

1824

m135046

1824

GA

141

m133284

141

ST266

1553

m134736

1553

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

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Shop Packet Print

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Picklist Print

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Work Order ID: 149009

149009

Parent Item: D139-799-033

D139-799-033

Parent Item Name: OEM Maintenance Step Cable Replacement

Start Date: 7/14/2016

Required Date: 7/19/2016

Start Qty: 3.00

Required Qty: 3.00

D5039-3 Manufactured No

Each 20.0000

D5039-3

Master Link

**

24

4X149039

PC DAS 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST143

20

130293

4

143469

16

16 4
16

D5040-1 Manufactured No

Each 42.0000

D5040-1

Chain

**

12

PC DAS 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST144

42

130296

2

142341

40

12

D5041-1 Manufactured No

Each 19.0000

D5041-1

Scuff Guard

**

12

PC DAS 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST144

19

130295

2

142338

17

1

DAS 27 9-89
D5348-1

274

Batch: 149755

DAS 6 9-89

JUL 18 2016

AUG 15 2016

DAS
27
9-89

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Qty 033	Qty -013	Part Number	Description
X	X	D139-799-013	CARGO DOOR HINGE KIT
		D139-799-033	OEM MAINTENANCE-STEP CABLE REPLACEMENT KIT
	1	D2585	MOUNTING CHANNEL
	1	D2586	DOOR LATCH
	1	D2621	LATCH PLATE
	1	D3552-23	DOOR PROP
	1	D3622-1	BALL STUD
	1	D3622-3	BALL STUD
	2	D4072-1	AIRFRAME HINGE
	2	D4072-3	AIRFRAME HINGE BACKING PLATE
	4	D4072-5	BUSHING
	2	D4073-1	DOOR HINGE
	2	D4073-3	DOOR HINGE BACKING PLATE
	1	D4074-1	BRACKET
	1	D4074-3	CHANNEL
	1	D4074-5	BACKING PLATE
	1	D4074-7	STRIKER PLATE
	1	D4519-1	RELAY BRACKET
	1	D4632-1	STRIKER PLATE
	1	D4632-2	STRIKER PLATE
	1	D4761-1	SHIM BLOCK
8		D5039-3	MASTER LINK
4		D5039-5	HALF LINK
4		D5040-1	CHAIN ASSEMBLY
4		D5041-1	SCUFF GUARD
4		D5348-1	DOUBLER
	1	IN4007	DIODE
	4	AN507-1032R12	SCREW
	4	AN507-1032R15	SCREW
4		AN525-832R9	SCREW
4		AN525-832R10	SCREW
8		AN525-832R14	SCREW
	1	M12883-41-19	RELAY BASE
	4	M39029/92-534	SOCKET CONTACT
	1	M83536/9-024M	RELAY
8	8	MS21042L08	NUT (or MS21042-08)
	32	MS21042L3	NUT (or MS21042-3)
	1	MS21042L5	NUT (or MS21042-5)
	8	MS24694-S47	SCREW
	8	MS27039-0807	SCREW
	8	MS27039-1-10	SCREW
	2	MS27039-1-14	SCREW
	8	MS27039-1-16	SCREW
	1	MS27039-1-17	SCREW
6		NAS1149C0332R	WASHER
	18	NAS1149D0363J	WASHER (or AN960JD10)
	1	NAS1149D0663J	WASHER (or AN960JD616)
	12	NAS1149D0332J	WASHER (or AN960JD10L)
	8	NAS1149DN832J	WASHER (or AN960JD8)
	4	NAS1515H-5L	WASHER